

**Work Order ID 71058**

Tuesday, June 21, 2011 1:32:00 PM

Page 1

Item ID: D2938-1

Accept

Revision ID:

Item Name: Saddle LH Out, 206

Start Date: 6/21/2011 Start Qty: 4.00

Required Date: 7/8/2011 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

11-06-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2938

Rev C

100

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

0.00

REQ 11-7-7

4

110

0.00



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Machine Keyway and inspect per attached dimension sheet

0.00

REQ 11-7-7

4

120

0.00



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

Memo

0.00

REQ 11-7-7

4

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71058

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Page 2

Item ID: D2938-1

Accept



Setup Start



Revision ID:

Item Name: Saddle LH Out, 206

Stop



Start Date: 6/21/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

SL 11/07/11



QC

Memo

0.00

Quality Control

(4)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

H BR 11-7-11

155

0.00



SprayPaint

Memo

0.00

Spray Painting

PRIME B 117319  
DELFLEET BLUE B 115985  
DELFLEET CLEAR B 117113

M 11 07 13 (4)

W/O:		WORK ORDER CHANGES					
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**Work Order ID 71058**

Tuesday, June 21, 2011 1:32:00 PM

Page 3

Item ID: D2938-1

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Setup Start

Revision ID:

Stop

Item Name: Saddle LH Out, 206

Start Date: 6/21/2011 Start Qty: 4.00

Required Date: 7/8/2011 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

165

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

81 11-07-14 (x4)

170

Identify as per dwg &amp; Stock Location: 424

0.00



Packaging

Memo

0.00

Packaging

11/7/10 S (y)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/15 AJ

11/07/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 21, 2011 1:32:06 PM

Page 1

Work Order ID: 71058

Parent Item: D2938-1

Parent Item Name: Saddle LH Out, 206



Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC  
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-003		Manufactured	No			100	Each	31.0000	1	4			
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Saddle Billet, 7075



125 11.7.7

Location	Loc Qty	Loc Code
MAT	5	
69701	5	
MAT040	20	
69678	20	
MAT45	6	
68172	6	

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 71058
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2938-1
<b>Inspection Dwg:</b> D2938 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.140	.140	.140	.140		
B	0.100	0.140		.140	.140	.140	.140		
C	0.100	0.140		.140	.140	.130	.130		
D	0.210	0.230		.220	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.110	.110	.110	.110		
O	0.540	0.560		.552	.552	.552	.552		
P	0.490	0.510		.500	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.741	2.741	2.741	2.741		
S	0.240	0.270		.250	.250	.250	.250		
T	0.100	0.180		.130	.130	.130	.130		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.260	1.260	1.259	1.259		
Y	1.565	1.585		1.569	1.569	1.573	1.573		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>DE</u>
Date: <u>11-7-7</u>

Audited by: <u>JK</u>
Date: <u>11/07/11</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

# Dart Aerospace Ltd

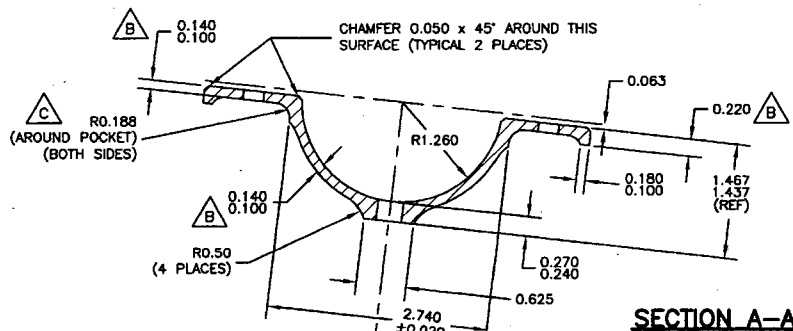
W/O:		WORK ORDER CHANGES					
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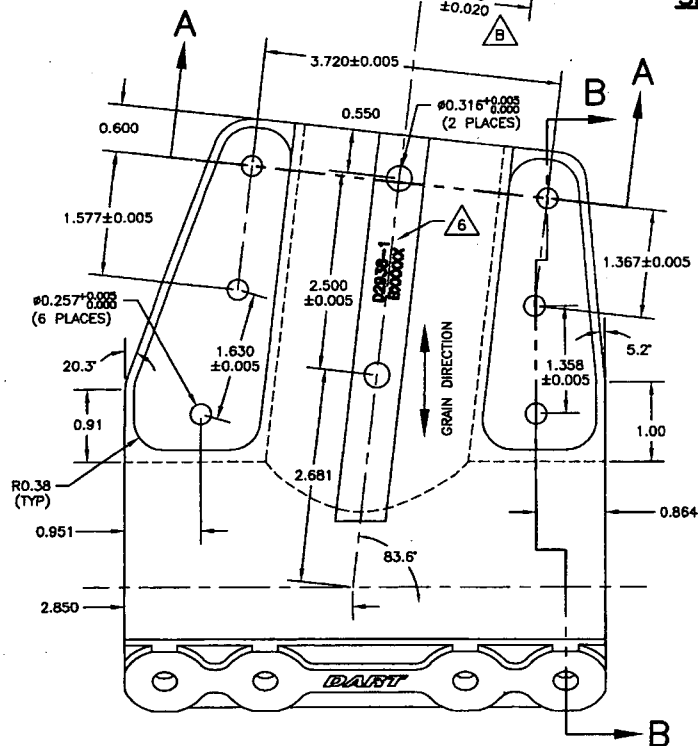
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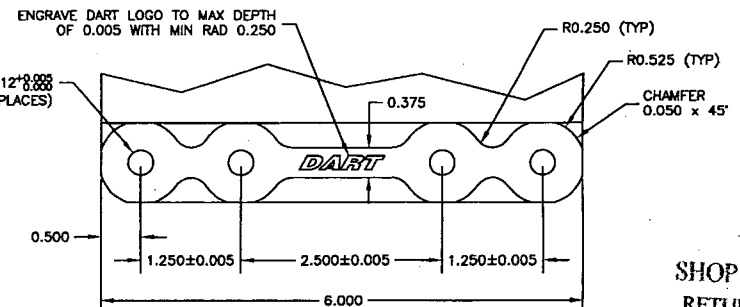
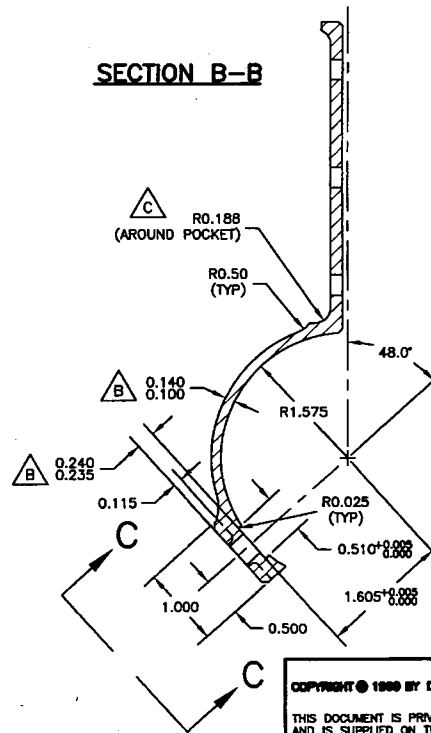
**NOTE:** Date & initial all entries



SECTION A-A



SECTION B-B



VIEW C-C

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71058

D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2938
DATE	TITLE	REV. C SHEET 1 OF 1 SCALE
06.11.09	SADDLE OUTSIDE	2-3

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DART AEROSPACE USA, INC.

07.02.12

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